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D5720-1
Job Sheet 200676



Part No: D5720-1

Job Qty: 10 pcs ^{10 DAS 21 3-89}

Part Name: Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 10/4/19

Type: SOLD

Description:

Note: DWG D5720 REV.A IPP REV:A 19.04.03 NEW ISSUE DD VERF:JFS IPP REV:B 19.04.23 AS PER REV.A
DWG DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	16 pcs		10/4/19	0.17	1.07	Waterjet - Flow	9/24/19	JRB
110	QC 2	16 pcs		10/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20	*	
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		

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Container No: S216404

Part: D5720 - 1

Job No: 200676

Serial No/Batch: S216404

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/24/19

PRICKLY

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	SRB 9/24/19
120 QC 8	16 pcs	10/4/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS SEP 24 2019 40
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	DAS 30 9-89
130 Small Fab - Brake NC - B4B	16 pcs	10/4/19	0.25 2.67	Small Fab - Brake - 1 - B4B	OCT 08 2019
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	16 pcs	10/4/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	DAS 81 9-89
				QC 5 - 49	OCT 08 2019
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	

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150	Packaging 3-1 - Stock - B4B	16 pcs	10/4/19	0.00 0.00	QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	62
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160	QC 21 - SA	16 pcs	10/4/19	0.00 0.00	QC 21 - SA - 21	Dwg 21
					QC 21 - SA - 70	8-89 OCT 09 2019
					QC 21 - SA - 53	

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - (QC8- Inspect parts - second check)

130 - Form as per dwg ***The tabs bend as per the dwg so that the D5720-5 radius block seats perfectly to D5720-1 rad*** ***USE DT10524 AS A TEMPLATE TO CHECK THE BEND RADIUS***

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Identify as per dwg & Stock Location: 1400)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M301S23GA-H50	301 SS SHEET, 12" x 36", 1/2 Hard Temper, 0.029" Thick	2.8480 sf (.178 ea)	100-Waterjet - Flow - 1	5215210
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M301S23GA-H50	3	0	0
Part Specifications				
Specifications could not be found.				

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Technical drawing of a mechanical part, likely a bracket or flange, showing dimensions and material specifications.

Dimensions:

- Overall width: 12.90
- Overall height: 1.900
- Top flange width: 0.400 (2 PL)
- Top flange hole diameter: $\phi 0.358$ (4 PL)
- Top flange hole spacing: 0.960 (4 PL)
- Top flange hole diameter: 0.500 (4 PL)
- Top flange hole diameter: 0.081 (7 PL)
- Top flange hole diameter: 0.16 (2 PL)
- Top flange hole diameter: 0.25 (8 PL)
- Top flange hole diameter: 0.33 (2 PL)
- Top flange hole diameter: 0.19 (4 PL)
- Top flange hole diameter: 0.35X0.25 CMF (4 PL REF)

Material Specifications:

- 8 PL
- 2 PL
- 4 PL
- 7 PL

Notes:

- 0.35X0.25 CMF 4 PL REF
- 0.56 TO BEND CENTERLINE (2 PL)

D5720-1F CLAMP
(FLAT PATTERN)

RELEASED
2019 APR 18

NOTES:
 1) MATERIAL: AISI 301 SS SHEET 1/2 HARD 23 GAUGE THICK (0.028) PER AMS 5518 OR ASTM A668
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 7) WEIGHT: 0.2200lbs

DESIGN	NO	DART AEROSPACE LTD HAWTHESBURY, ONTARIO, CANADA SADDLE CLAMP COPYRIGHT © 1988 BY DART AEROSPACE LTD THIS DRAWING IS UNCLASSIFIED AND IS AVAILABLE TO THE PUBLIC WITHOUT FEE. FOR INFORMATION CONTACT THE NATIONAL ARCHIVES AT OTTAWA.	TITLE	D5720	REV. A
DRAWN	NO		DRAWING NO.	SHEET 2 OF 4	
CHECKED	ZF			SCALE	
MFG. APPR.	DD			NITS	
APPROVED	CP				
DE APPR.					
DATE	19-03-01				

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